



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5953

Job Sheet 173833



Part No: D5953

Job Qty: 6 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/7/18

Job Tracking No:

Due Date: 4/12/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP Rev:E Re-Format 05-11-29 JLM IPP Rev:f ecn 826 06.12.06 EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		4/11/18	0.00	0.00	Start Up Machining-4		\$BL 18/03/27
100	CNC Vertical Machining	6 pcs		4/11/18	0.79	15.79	HAAS1-1		\$BL 18/03/27
110	QC	6 pcs		4/11/18	0.00	0.00	QC1		\$BL 18/03/28
120	QC	6 pcs		4/11/18	0.00	0.00	QC8 Machining-4		A. 18-03-28
130	HandFinish	6 pcs		4/11/18	0.00	0.55	HandFinish1		SA 18-03-28
140	Powdercoat	6 pcs		4/12/18	0.00	0.28	Powdercoat1		BR 18-4-3
150	QC	6 pcs		4/12/18	0.00	0.00	QC3		11 APR 03 2018
160	Packaging	6 pcs		4/12/18	0.00	0.00	Packaging3-2		21 APR 04 2018
170	QC21-SA	6 Ea		4/12/18	0.00	0.00	QC21		21 APR 04 2018

Part Op 100 - 1-Machine as per folio D5953, Ensure Batch Number is entered

Descriptions: 110 - Inspect on CMM as per folio CMM017

140 - START TIME: 10:45 AM T: 5:00 PM FINISH 11:15

MB8760

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	6 Ea (1 ea)	90-Start up Operation	

5038648 → 5038648

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-007	6	11	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition
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Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 813 632-6200
 Email: sales@dartaero.com
 www.dartaerospace.com

Date: 03/27/18

Root Cause			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	
Design ☐	Operator ☐	Bending ☐	
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	
Equip/Tooling ☐	Supplier ☐	Cracks ☐	
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	
Material ☐	Use for Testing ☐	Cuffs ☐	
Internal Transport ☐	Poor Information ☐	Crushing ☐	
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		
		OTHER :	



Container No: S055148



Part: D5953

Job No: 173833

Serial No/Batch: S055148

Revision: _____
Inspector: _____

☐ Countersink	☐ Off-set	☐ Drawing
☐ Cut Too Short	☐ Mis-labeled	☐ Finish
☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

SHOP COPY

RETURN TO
ENGINEERINGUNCONTROLLED
SUBJECT TO AMENDMENT**DART**

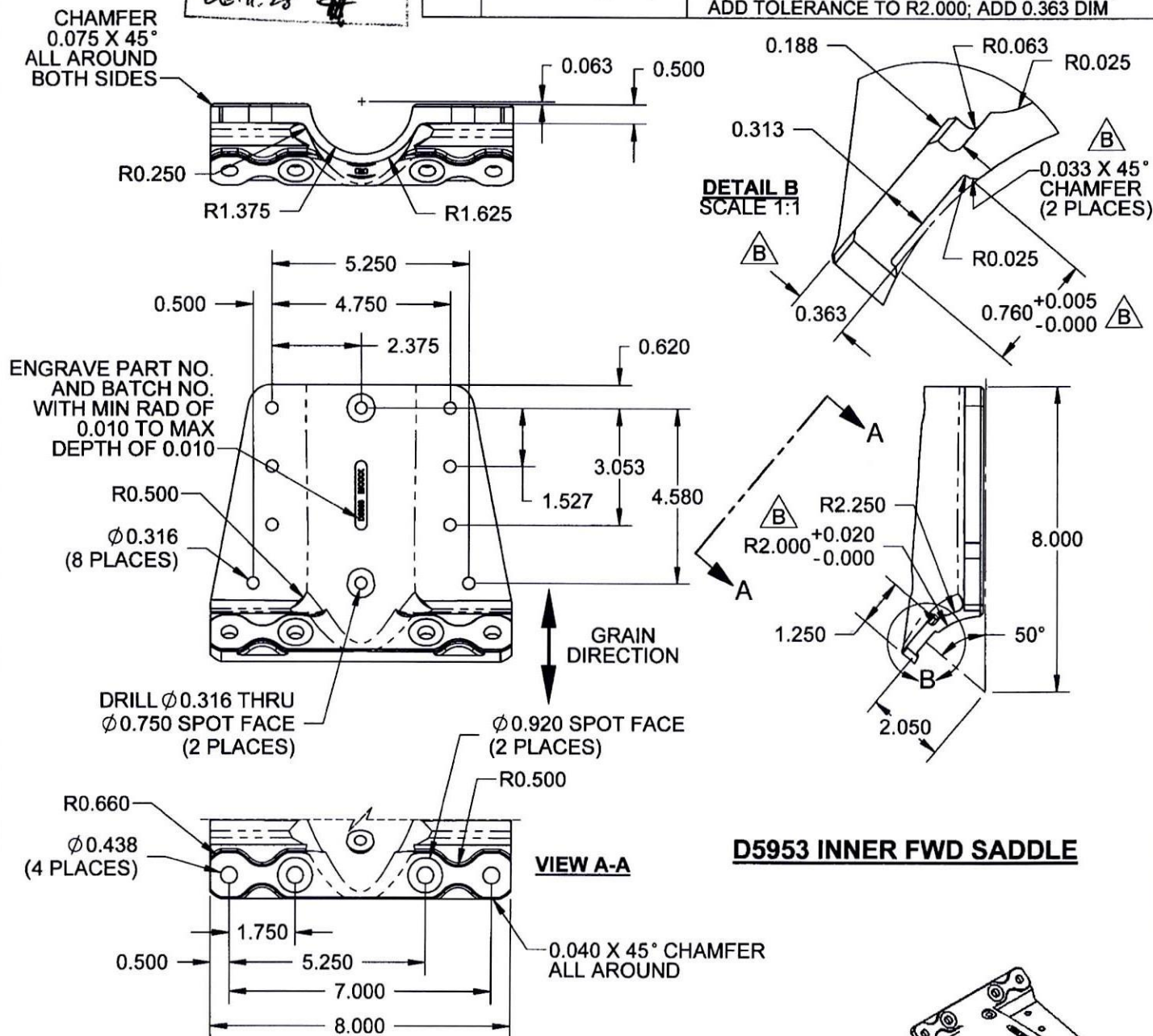
WITHOUT NOTICE

WORK ORDER

NO. 173833

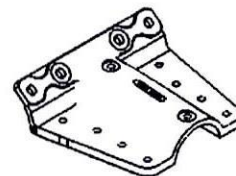
MAR 07 2018

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5953	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER FWD SADDLE SCALE 1:4		
REV	DATE	DESCRIPTION	
A	97.05.06	NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**
SCALE 1:8

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DART AEROSPACE LTD		Work Order: 173833
Description: Inner Fwd Saddle		Part Number: D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.25	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.240	5.260		5.250	5.250	5.250	5.250		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		0.316	0.316	0.316	0.316		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.054	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.315	0.322		0.316	0.316	0.316	0.316		
L	0.495	0.505		0.500	0.500	0.500	0.500		
M	0.490	0.510		0.500	0.498	0.499	0.499		
N	1.615	1.635		1.625	1.625	1.625	1.625		
O	7.990	8.010		8.000	8.000	8.000	8.00		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		0.312	0.311	0.311	0.311		
R	0.760	0.765		0.760	0.760	0.760	0.760		
S	0.490	0.510		0.498	0.500	0.500	0.499		
T	1.375	1.395		1.375	1.375	1.375	1.375		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: SBL/ank
Date: 18/03/27

Audited by: A.E
Date: 18-03-28

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	

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B	1.745	1.755		1.750					
C	5.245	5.255		5.250					
D	6.995	7.005		7.000					
E	5.240	5.260		5.250					
F	4.745	4.755		4.750					
G	0.315	0.322		0.310					
H	1.522	1.532		1.527					
I	3.048	3.058		3.053					
J	4.575	4.585		4.580					
K	0.315	0.322		0.310					
L	0.495	0.505		0.500					
M	0.490	0.510		0.499					
N	1.615	1.635		1.625					
O	7.990	8.010		8.000					
P	2.240	2.260		2.250					
Q	0.307	0.312		0.311					
R	0.760	0.765		0.760					
S	0.490	0.510		0.500					
T	1.375	1.395		1.375					
U	2.000	2.020		2.000					
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: SBL
Date: 18/03/27

Audited by: D.F.
Date: 18-03-28

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	
D	07.06.15	Dimension G revised	KJ/JLM	
E	08.04.21	Dimension E revised	KJ/DD	
F	08.12.01	Dimension K revised	KJ/DD	